

Date: Tuesday, 19/08/2008 4:05:24 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 41469			Part Number	: D35742		
Estimate Number	: 12661			Drawing Number	: D3574 REV.A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/08/2008	S.O. No.	:	Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 05/09/2008		
Previous Run	: 40645			Qty:	4	Um:	Each
Written By	:			Comment	: Est Rev :A New Issue 07-01-22 EC		
Checked & Approved By	: <u>NO 08.8.19</u>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Comment: Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s) lexan sheet Batch: <u>109455</u> <u>BS 8-10-1</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: <u>A</u> <u>BS 8-10-1</u> <u>(4)</u> Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>BS 8-10-1</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>m</u> <u>BS 8-10-1</u> <u>08-10-01</u> <u>(4)</u> <u>(4)</u>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Deburr if necessary. <u>SAD 08/10/05</u> <u>(4)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-01	2.0	1 Part scrap. Holes : Top : curved edge are shifted						

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 41469

Part Number: D35742

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



8/08/08 (40)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



(40)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: PPP 41310 81010

SG

8.0 QC21 FINAL INSPECTION/W/O RELEASE



08/10/08 (40)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>41469</u>
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.08	X		Tape	
7.37	+/-0.030	7.37	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
53.51	+/-0.030	53.51	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	X			
10.75	+/-0.030	10.75	X			
14.75	+/-0.030	14.75	X			
25.50	+/-0.030	25.50	X			
25.75	+/-0.030	25.75	X			
26.00	+/-0.030	26.00	X			
32.87	+/-0.030	32.87	V			
38.81	+/-0.030	38.81	X			
45.00	+/-0.030	45.00	X			
58.38	+/-0.030	58.38	X			
61.25	+/-0.030	61.25	X			
64.13	+/-0.030	64.13	X			
64.63	+/-0.030	64.63	V			
7.50	+/-0.030	7.50	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
10.88	+/-0.030	10.88	X			
14.50	+/-0.030	14.50	X		V	
16.56	+/-0.030	16.56	X			

DART AEROSPACE LTD		Work Order: 41469
Description: Cabin Floor Protector		Part Number: D3574-2
Inspection Dwg: D3574	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

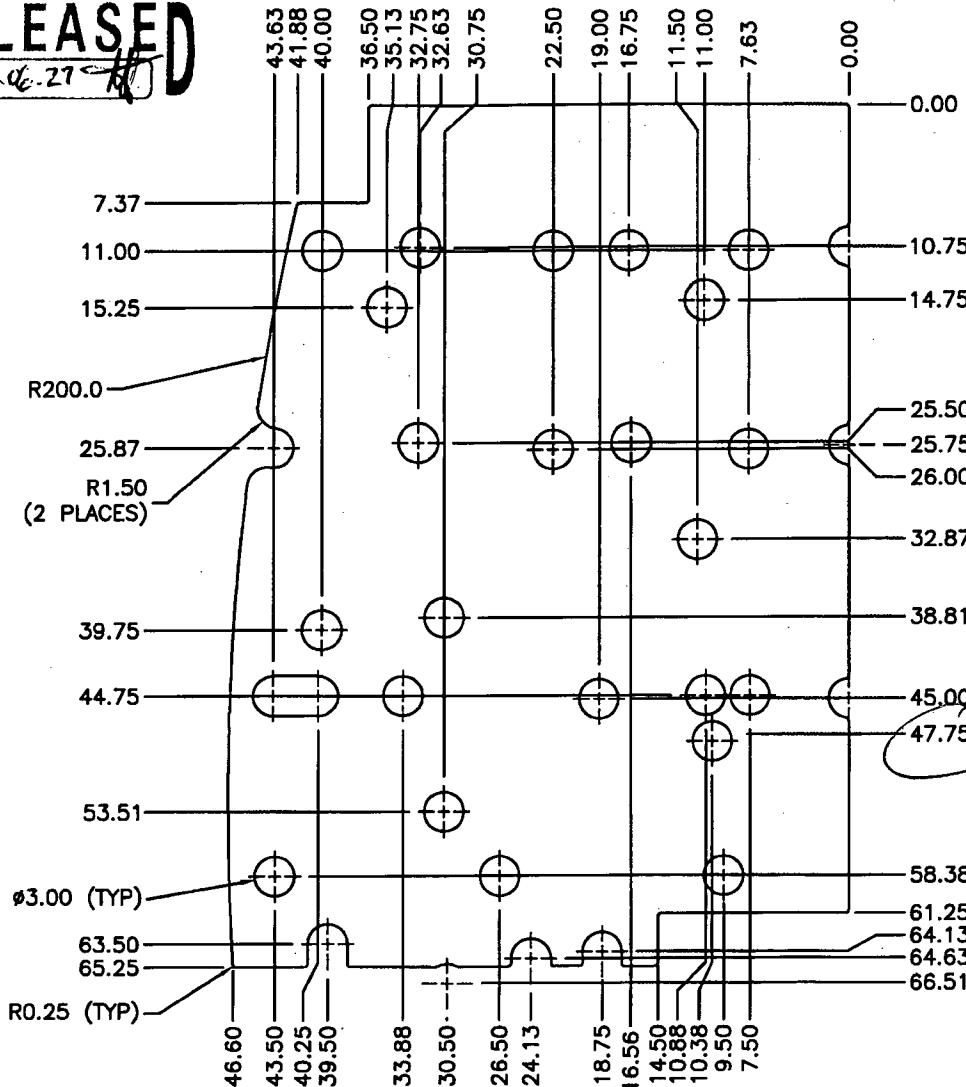
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.75	+/-0.030	18.75	*		M. Tape	
24.13	+/-0.030	24.13	x			
26.50	+/-0.030	26.50	x			
30.50	+/-0.030	30.50	x			
33.88	+/-0.030	33.88	x			
39.50	+/-0.030	39.50	x			
40.25	+/-0.030	40.25	x			
43.50	+/-0.030	43.50	x			
46.60	+/-0.030	46.60	x			
7.63	+/-0.030	7.63	x			
11.00	+/-0.030	11.00	x			
11.50	+/-0.030	11.50	x			
16.75	+/-0.030	16.75	x			
19.00	+/-0.030	19.00	x			
22.50	+/-0.030	22.50	x			
30.75	+/-0.030	30.75	x			
32.63	+/-0.030	32.63	x			
32.75	+/-0.030	32.75	x			
35.13	+/-0.030	35.13	x			
36.50	+/-0.030	36.50	x			
40.00	+/-0.030	40.00	x			
41.88	+/-0.030	41.88	x			
43.63	+/-0.030	43.63	x			

Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	8-10-01	Date:	08-10-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	BB

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR
		SCALE 1:14
A	07.06.08	NEW ISSUE

RELEASED
07.06.27 *CH***D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER NOTICE WORK ORDER NO. *41410*
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

NOTICE

WORK ORDER

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>HF</i>	DRAWING NO. D3574
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR

REV. A

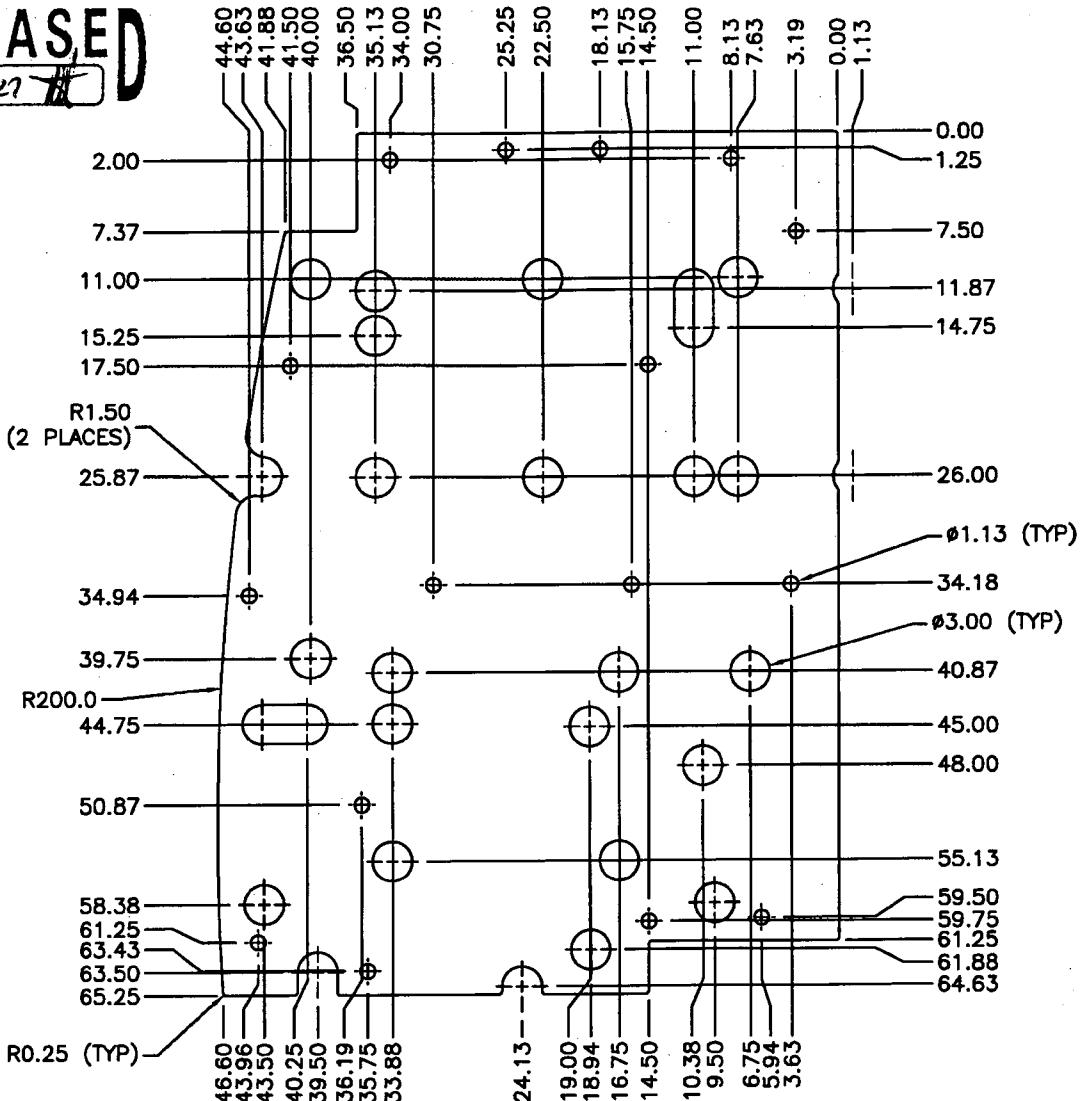
SHEET 2 OF 5

SCALE

1:14

RELEASED

07.06.08

D3574-3 CABIN FLOOR PROTECTORNOTES:

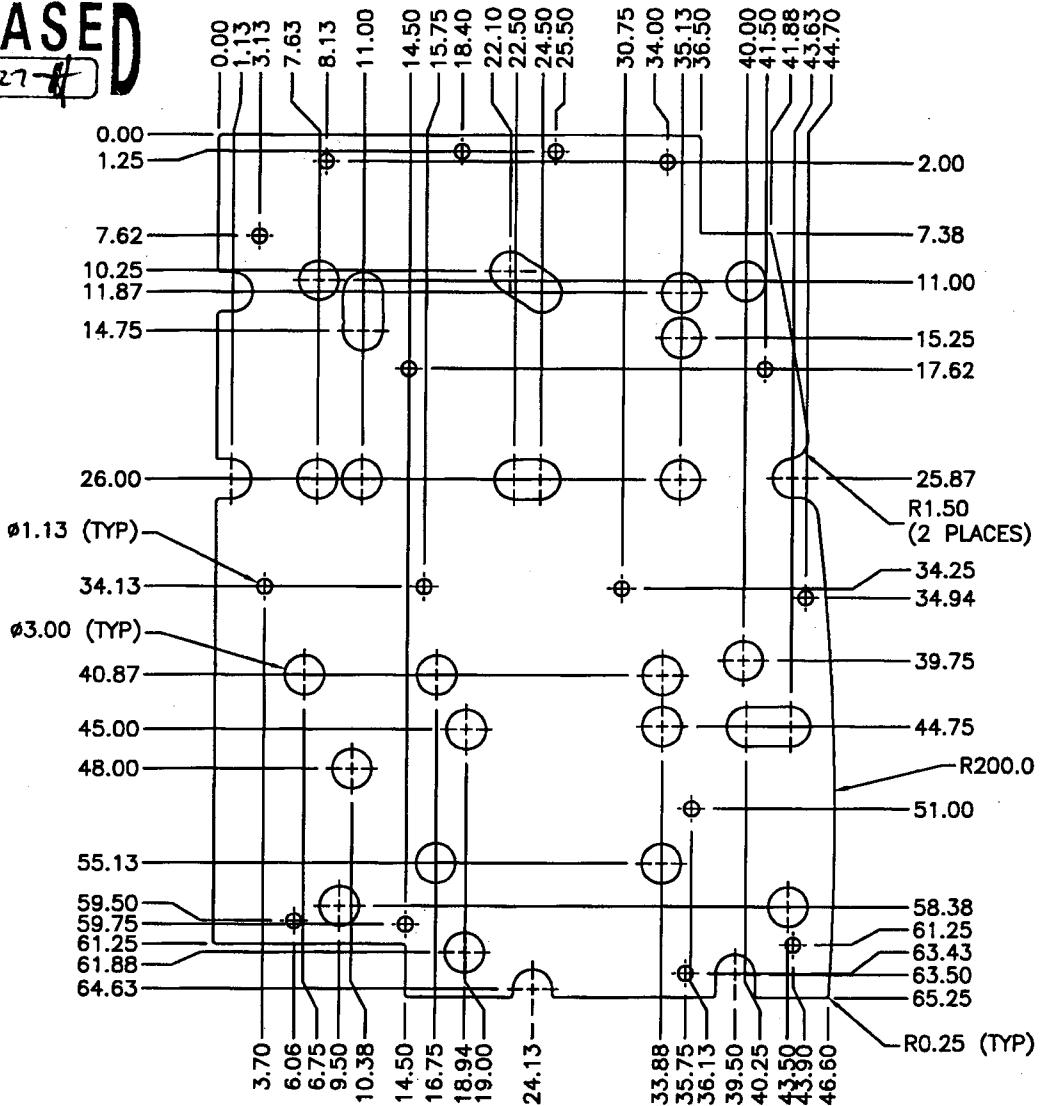
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP COPY
- 2) FINISH: NONE RETURN TO ENGINEERING
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED CONTROLLED COPY
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER SUBJECT TO AMENDMENT
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED WITHOUT NOTICE
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX WORK ORDER
- 7) CHECK PER TEMPLATE DT8962 NO. 41469

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574	REV. A SHEET 3 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

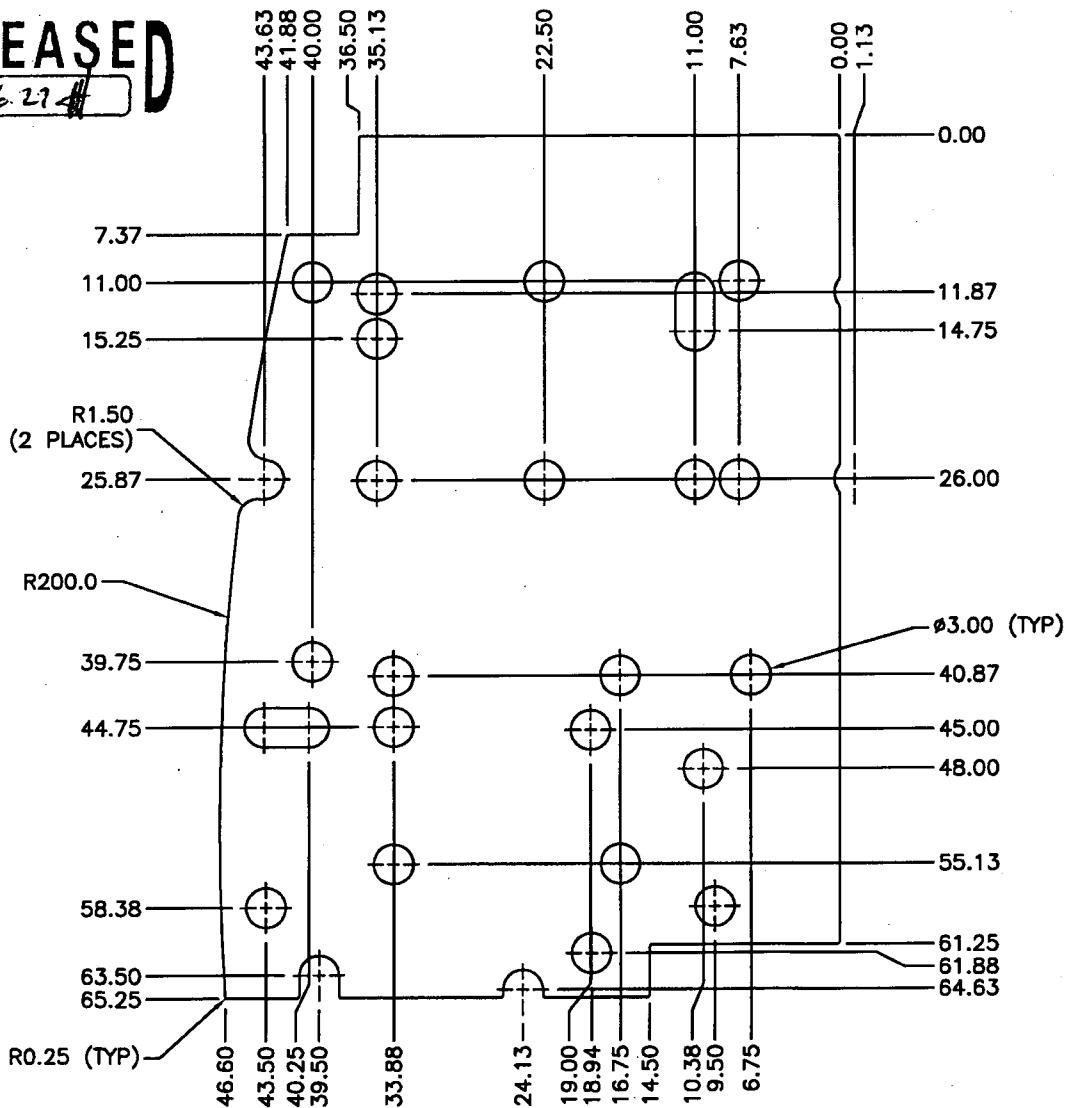
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK. SHOP COPY
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED COPY
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK SUBJECT TO AMENDMENT
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX MARKER
WITHOUT NOTICE
- 7) CHECK PER TEMPLATE DT8963 WCRK ORDER
NO. 41469

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>ff</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 ff**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO ENGINEERING
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED COPY
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER INDENT WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

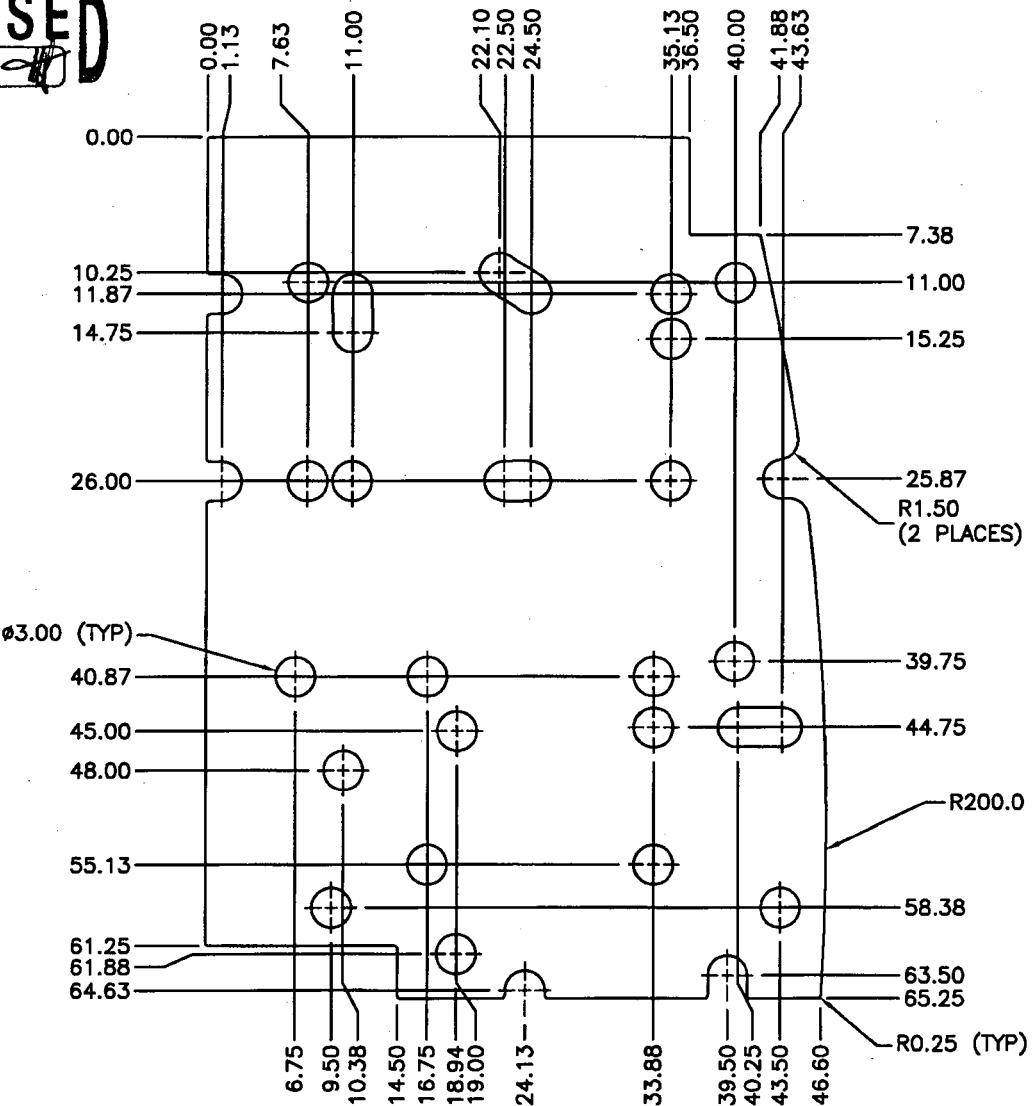
WORK ORDER NO. *111469*

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>dk</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 *dk***D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP COPY
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

RETURN TO
 ENGINEERING
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *41469*

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.